

Work Order ID 127177

127177

Page 1

Monday, December 15, 2014 8:11:18 AM

Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid
 Start Date: 12/15/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/15/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-12-15 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2512	G

100 Weld per dwg A/R S.S. rod Batch: B125054 0.00
 Large Fab

100

Large Fab Memo 0.00
 1- Weld ribs as per Dwg D2512 using Welding Jig DT 9436
 INSTALL D2012-117 CLEVIS ONLY ON D130-701-XXX

Large Fab
 2- WELD MESH AND REMOVE SECTIONS OF MESH WHERE INDICATED AS PER DWG

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00
 Quality Control

1x CC 15-1-7

JAN 08 2015

DAS
24
9-89

Monday, December 15, 2014 8:11:18 AM

Item ID: D2512

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Basket Lid

Stop *NS2*

Start Date: 12/15/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/15/2014 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			DAS 24 9-89
		JAN 08 2015	

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

DAS 34 99

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
130	<i>M 129808</i>					<i>1</i>	<i>0</i>	<i>15-1-8</i>	<i>238</i>
Powdercoat	Memo	0.00							
Powder Coating	1- Plug all holes prior to Powdercoat								
	1ST COAT:								
	START TIME: <i>11:00</i>								
	OVEN TEMPERATURE: <i>1200</i>								
	FINISH TIME: <i>11:30</i>								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	HandFinishing	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing	Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4								
	Batch: <i>11130390</i>								
						<i>1x</i>	<i>1</i>	<i>15/01/09</i>	

Picklist Print

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Work Order ID: 127177

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Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R
 10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS
 PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG
 REV.G DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117		Manufactured	No			100	Each	20.0000	2	2			

D2012-117

Clevis

Location

Loc Qty

Loc Code

WA004

20

124563

11

125440

9

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

N/A M/S 1501-09

D2232-1

Manufactured No

100

Each

39.0000

2

2

D2232-1

Basket Hinge

Location

Loc Qty

Loc Code

WA004

39

105333

15

105885

24

N/A
 CC 15-1-7
 (2)

Picklist Print

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Work Order ID: 127177

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Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 1.00

Required Qty: 1.00

D2236

Manufactured No

100 Each 8.0000 4 4

D2236

Lid Rib

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

8

124995

8

(4x)

D2506

Manufactured No

100 Each 24.0000 1 1

D2506

Label Plate

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

24

102257

17

103156

2

99826

5

(1x)

D2512-3

Manufactured No

100 Each 2.0000 2 2

D2512-3

Rib

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

2

B120776

105310

2

(2x)

125143
124898

D2512-5

Manufactured No

100 Each 6.0000 6 6

D2512-5

Rib

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

6

B125387

124956

6

(6x)

Picklist Print

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Work Order ID: 127177

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Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 1.00

Required Qty: 1.00

D2512-7 Manufactured No

100 Each 2.0000 3 3

D2512-7

Rib

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

2

B125423

(3x)

107695

1

97300

1

D2581 Manufactured No

100 Each 98.0000 2 2

D2581

Mounting Bracket

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

98

102265

58

122730

40

D3825-043 Manufactured No

100 Each 6.0000 2 2

D3825-043

Rib Assembly (Basket End, Lid)

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

6

124955

6

D3832-13 Manufactured No

100 Each 0.0000 1 1

D3832-13

Mesh (Lid)

D3833-7

Manufactured No

100 Each 13.0000 2 2

D3833-7

Mesh (Lid End)

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA006

13

B117178

(2x)

105442

1

114377

12

QTY	PART NUMBER	DESCRIPTION
X	D2512	BASKET LID ASSEMBLY
2	D2512-3	RIB
6	D2512-5	RIB
3	D2512-7	RIB
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-13	MESH (LID)
2	D3833-7	MESH, LID END

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

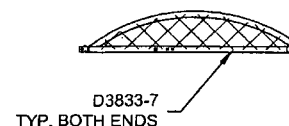
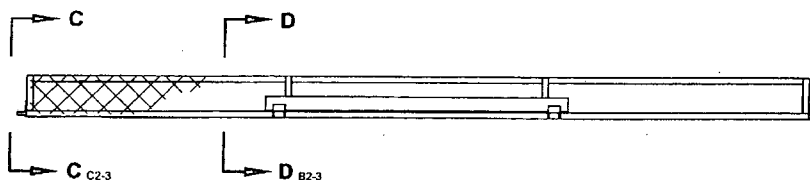
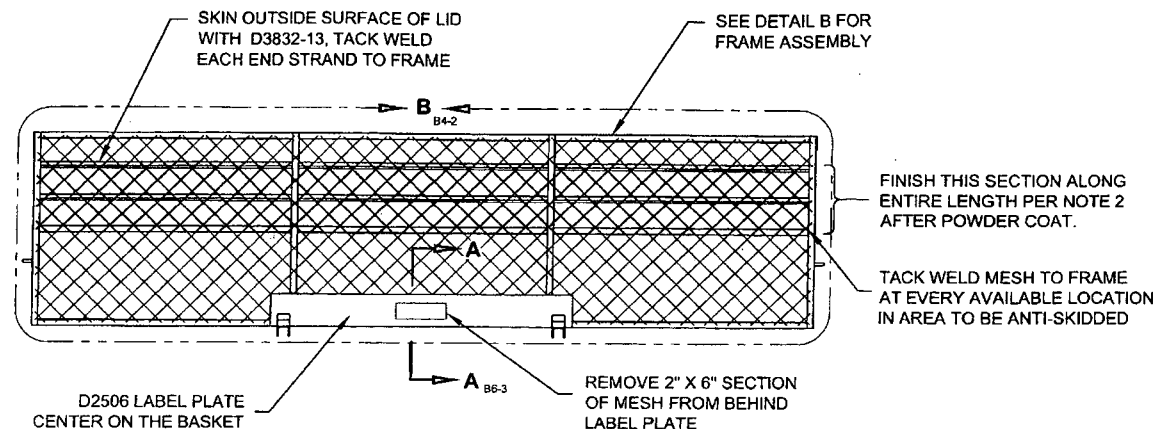
WITHOUT NOTICE

WORK ORDER

NO. 127137 MJS

14-12-15

RELEASED
2012-00-03



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
AFTER POWDER COAT, SPRAY PAINT BLACK INSIDE SURFACE AND
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACES PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

G	CORRECTED TYPO: D3825-043 WAS D3825-041 (ZN D3-1, B8-2, B1-2)	MB	12.07.26
F	GENERAL REVISION: REFORMATED DWG; DELETED DETAIL E AND RELATED NOTES IN VIEW C-C. REASON: PAR10-50.	MB	12.05.11
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO. D2512	REV. G
MFG. APPR.			SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

D

C

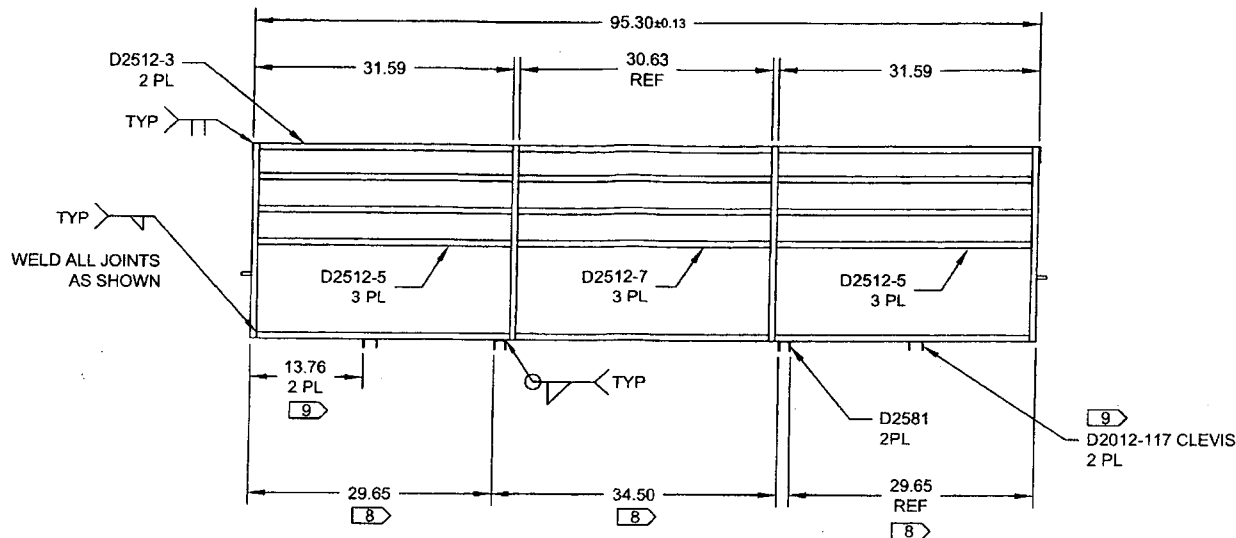
C

B

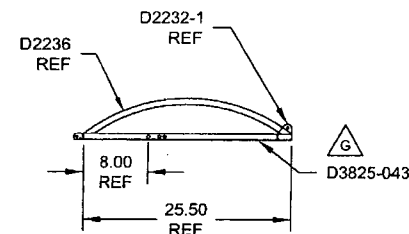
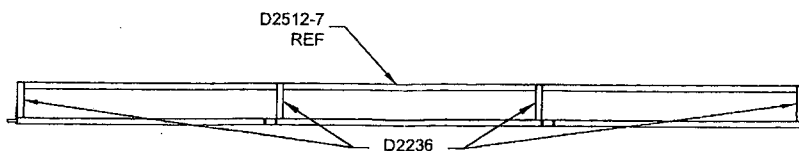
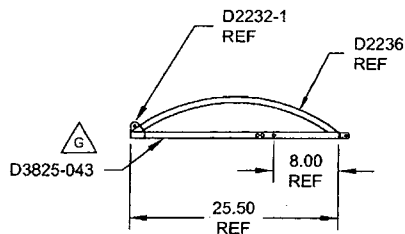
B

A

A



DETAIL B D6-1
FRAMEWORK ONLY SHOWN FOR CLARITY



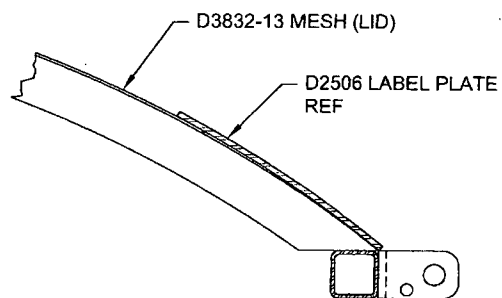
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2012-00-03

NOTES:

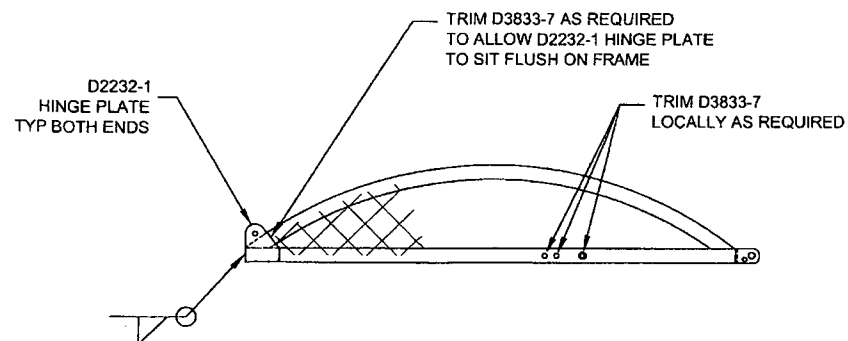
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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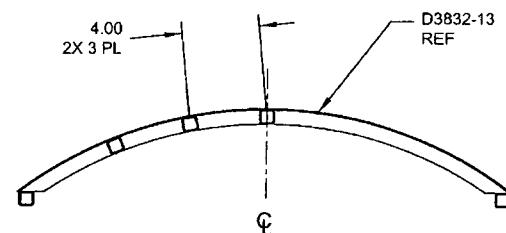
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SECTION A-A
(ROTATED 90° CCW) C6-1



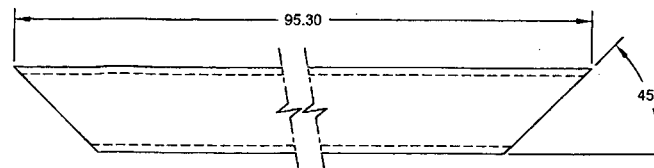
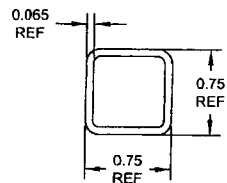
VIEW C-C SIMILAR BOTH END RIBS B8-1



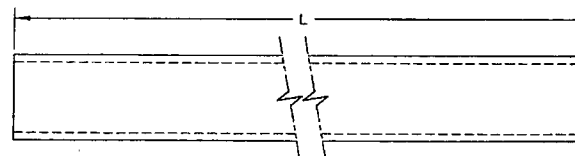
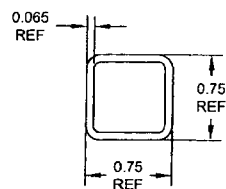
SECTION D-D SAME BOTH CENTER RIBS B7-1

RELEASED
2012-08-03
JMP

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D2512	REV. G
MFG. APPR.		SHEET 3 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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D2512-3 RIB



D2512-X RIB

DART PART NUMBER	L
D2512-5	30.84
D2512-7	30.63

D2512-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2012-08-03
JW

DESIGN	BW	DART AEROSPACE LTD
DRAWN	R	HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. REV. G
MFG. APPR.	JW	D2512 SHEET 4 OF 4
APPROVED	JW	TITLE SCALE
DE APPR.	JW	BASKET LID ASSEMBLY (350/212) NTS
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